Work Orde Tuesday, April 2												Page 1
Item ID:	D3278-041	71.1	A	Accept					s	Setup St	art	
Revision ID: Item Name:	Support Assen	nbly	·.							St		
Start Date: Required Date: Reference:	4/26/2011 4/29/2011	Start Qty: 40.00 Req'd Qty: 40.00	!			st Item I stomer:	D:					
Approvals:	Process Pla	nn:	Date://-04-36	Tooling: SPC (Y/N):			nte:					
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	To	ool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. r Stamp
Draw Nbr	Rev	rision Nbr										100000000000000000000000000000000000000
D3278	Rev	C										
100		Small Fab		0.00							1/2	0/4
Small Fab		Memo		0.00						11/10	7/2	
Small Fab		QC5- Inspect part comp	oleteness to step on W/O	0.00	. la a				contr	2		
QC		Memo		0.00 لازدر	(124				(740)) <u> </u>		

120

Small Fab

Quality Control

Small Fab

Small Fab

Memo

Assemble support as per Dwg D3278.□***DO NOT TIGHTEN BOLTS***□Identify as D3278-041

0.00

0.00

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	l						
	R	esolution:						Date: _	
NCR:		•	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section		Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial	Action Description	Sign	& Section		Chief Eng	QC Inspector
	1		Chief Eng	Chief Eng	Date	<u> </u>		Offier Eng	QO moposto.
			Chiệt Eng	Chief Eng	Date		0	Office Eng	QO mapasion
			Chiệt Eng	Chief Eng	Date			Ciller Eng	QU III SPOSIO
			Chiệt Eng	Chief Eng	Date			Ciller Ellig	do moposio.
			Chief Eng	Chief Eng	Date			Ciller Ellig	
			Chief Eng	Chief Eng	Date			Ciller Ellig	

Work Order ID 68957

Tuesday, April 26, 2011 12:58:37 PM



Page 2

Item ID:

D3278-041

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 4/29/2011

Support Assembly

4/26/2011

QC:

Start Qty: 40.00

Req'd Qty: 40.00



Date:_____

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N):

Set Up/

Date: Date: Run

Start Stop



Sequence ID/

Work Center ID

130

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Run Hours 0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

Memo

Notolu B 000

140

Packaging

Packaging

Memo

Identify as per dwg & Stock Location:

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE	CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault	Category:		NCI	R: Yes	No DQ	A:	Date: _			
	Re	esolution:	Disp	osition:		QA:	N/C Clo	osed:		Date: _			
NCR:			WORK (ORDER NO	N-CONFORM	MANCE	(NCR)					
DATE	STEP	Description of NC			····	ection B		Verifi	cation	Approval	Approval		
DATE	SIEP	Section A	in tia Chief E		ction Descriptior Chief Eng	n 	Sign & Date		ion C	Chief Eng	QC Inspector		
										1			
											-		
					1 ,								
				1									
	1										1		

Picklist Print

Tuesday, April 26, 2011 12:58:43 PM

Work Order ID: 68957

Parent Item:

D3278-041

Parent Item Name: Support Assembly



Start Date: 4/26/2011

Required Date: 4/29/2011

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: □A□04.04.19□New issue□KJ/JLM□

D 07.09.21 Charivet per DAD 195

EC Varified by IIM

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
03278-1 		Manufactured	No	·		100	Each	45.0000		40 55 14	104/0	18	
				Location	:	Loc	<u>Oty</u>	Loc Code					
				GA			45			,			
					66948		4		_	4	-		
					67772		41		_	36			
03278-2 		Manufactured	No			100	Each	40.0000		40	1/04/	be	
				Location	!	Loc	<u>Oty</u>	Loc Code					
				GA			40						
					67769		40		_	40	_		
03278-3 		Manufactured	No			100	Each	114.0000		40	[/o/j	28	
				Location	1	Loc	<u>Otv</u>	Loc Code					
				GA			114			,			
					66547		4		_	4	-		
					68340		110			26	-		

W/O:			V	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					·				
Part No		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposit	ion:	QA: N/C C	osed:		Date: _	
NCR:		1	WORK OR	DER NON-CONFORM	ANCE (NCF	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	Sign &	Secti	cation on C	Approval Chief Eng	Approval QC Inspector
				o.no. Eng					
****		,							

Tuesday, April 26, 2011 12:58:44 PM

Work Order ID: 68957

Parent Item:

D3278-041

Parent Item Name: Support Assembly



Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Nut

Purchased

Purchased

No

100

Each 5,256.000

Location Loc Qty Loc Code ST300 5256 116188 256 116823 2000 117441 3000

80

AN4-13A

Bolt

AN960JD416

No

120 Each 335.0000

Location Loc Oty Loc Code ST357 335

No

NAS1149D0463J Purchased

M117065 Washer D2230-1 Manufactured

Lug

117313 120

67761

335 Each

Each

100

0.0000

155.0000



Location Loc Qty Loc Code ST476 155 65270 2 67396 53

120

W/O:				j M	ORK ORDER CHANGES					
DATE	STEP	PRO	CEDUI	RE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No				1	tegory:N					
	R	esolution:	Dis	posit	ion: Q	A: N/C C	osed:		Date: _	
NCR:			VORK	OR	DER NON-CONFORMANC	E (NCF	R)			
DATE	STEP	Description of NC Section A		tial f Eng	Corrective Action Section B Action Description Chief Eng	Sign &	& Secti	cation ion C	Approval Chief Eng	Approval QC Inspector
								·		

Picklist Print

Tuesday, April 26, 2011 12:58:44 PM

Work Order ID: 68957

Parent Item:

D3278-041

Parent Item Name: Support Assembly



Start Date: 4/26/2011

Required Date: 4/29/2011

Page 3

Start Qty: 40.00

Required Qty: 40.00

MS20426AD3-6

Purchased

No

120

3,909.000

Each

Loc Code

Rivet

Location Loc Qty ST316 3909 105055 339 116289 3570

Tuesday, April 26, 2011 12:58:44 PM

Shop Packet Print

Page 3

W/O:				V	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	CEDUI	TE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									į.		
Part No		PAR #:	Fa	ult Ca	tegory:	NCF	l: Yes I	No DQ	A:	Date:	
		esolution:		1							
NCR:		V	VORK	OR	DER NON-CONFORMA	NCE	(NCR)		***************************************	
DATE	STEP	Description of NC Section A		tial of Eng	Corrective Action Section Action Description Chief Eng	on B	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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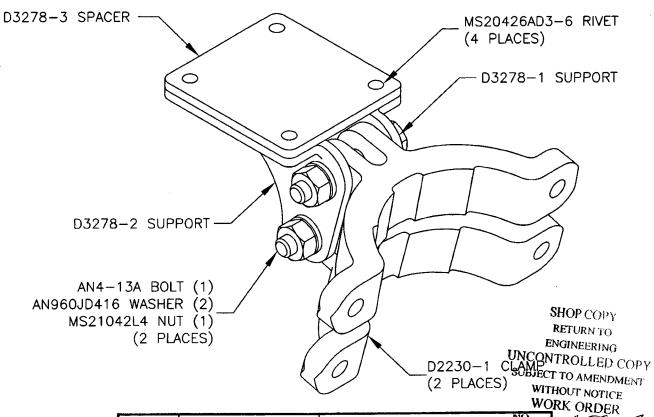


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CHEC	KED	APPROVED,	DRAWING NO. REV. C
	_#	dt	D3278 SHEET 1 OF 3
DATE			TITLE SCALE
07.0	07.24		SUPPORT ASSEMBLY NTS
Α		04.03.03	NEW ISSUE
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT
С		07.07.24	CHANGED RIVETS PER PAR #185

d11-04-24

DELEASED

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description	NO
Х	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

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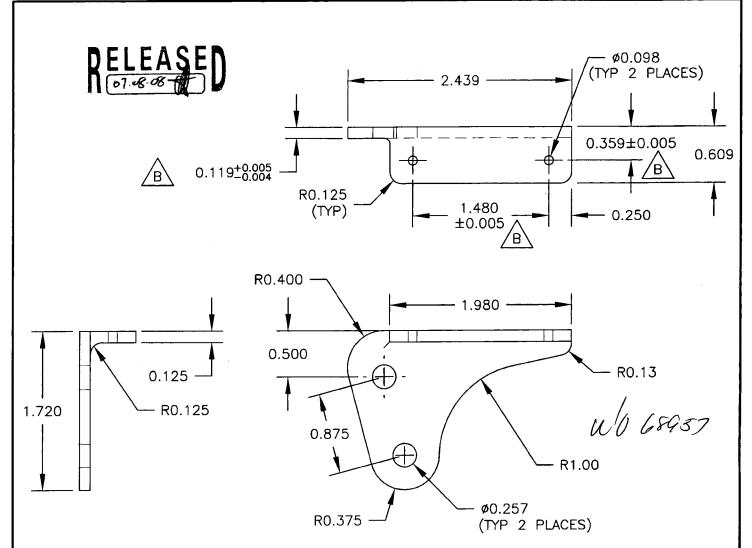
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Dart Aerospace Ltd	Da	ırt	Ae	ro	sp	ac	e L'	td
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W/O:			W	ORK ORDER CHA	ANGES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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<u>,</u>					1					
Part No		PAR #:			1					
···	Re	solution:			<u> </u>				Date: _	
NCR:		`	WORK ORD	DER NON-CONFO	RMANC	E (NCR	(1)			
DATE	STEP	Description of NC Corrective Action				0: 0	Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion 	Sign & Date	Sec	ion C	Chief Eng	QC Inspector
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#	-#	D3278	SHEET 2 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

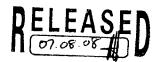
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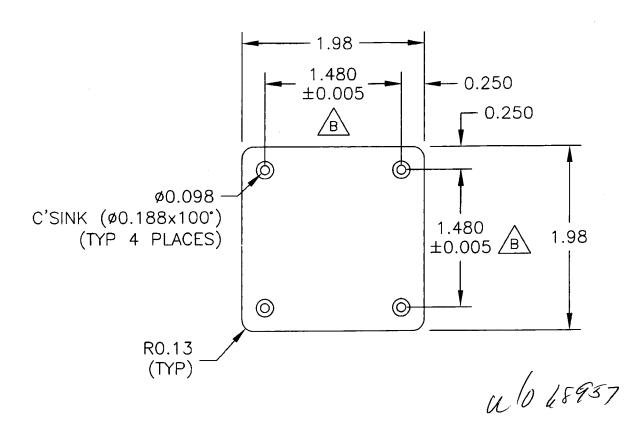
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W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									i		
Part No		PAR #: Fault Category:			NCR: Yes No DQA: Date:						
					QA: N/C Closed:						
NCR:			WORK ORI	DER NON-CONFO	RMAN	CE (NCR)				
DATE	STEP	Description of NC Section A			Section B	Verit		ication	Approval	Approval	
			Initial Chief Eng	Action Descri Chief Eng	tion	Sign & Date		ion C	Chief Eng	QC Inspector	
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# A	-#	D3278	SHEET 3 OF 3
DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1





D3278-3 SPACER

1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL (REF. DART SPEC. M-DELRIN-B0.125x2.000) OR

DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-S.125)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Ca	tegory:	,	ICR: Yes	No DQ	A:	Date: _	
Reso		lesolution:	Disposit	ļ c	A: N/C CI	osed:	Date:			
NCR:		V	VORK OR	DER NON-CONFO	RMAN	CE (NCF)			
DATE	STEP	Description of NC Section A	Corrective Action		ļ	Section B		Verification	Approval	Approval
			Initial Chief Eng	Action Descrip Chief Eng	ition 	Sign 8 Date		Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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